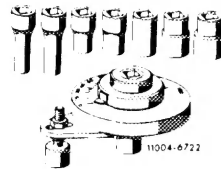


Tightening torques		Nm	(kpm)
Waisted bolt for camshaft sprocket		80	(8)
Big-end clamp nuts	Initial torque	40–50	(4–5)
	Final torquing angle	90–100°	
Waisted bolts for flywheel and driven plate	Initial torque	30–40	(3–4)
	Final torquing angle	90–100°	
Crankshaft bearing bolts		90	(9)

#### Special tool

Torquing angle set



116 589 01 13 00

#### Shop-made tool

Gauge to cut off aft radial seal

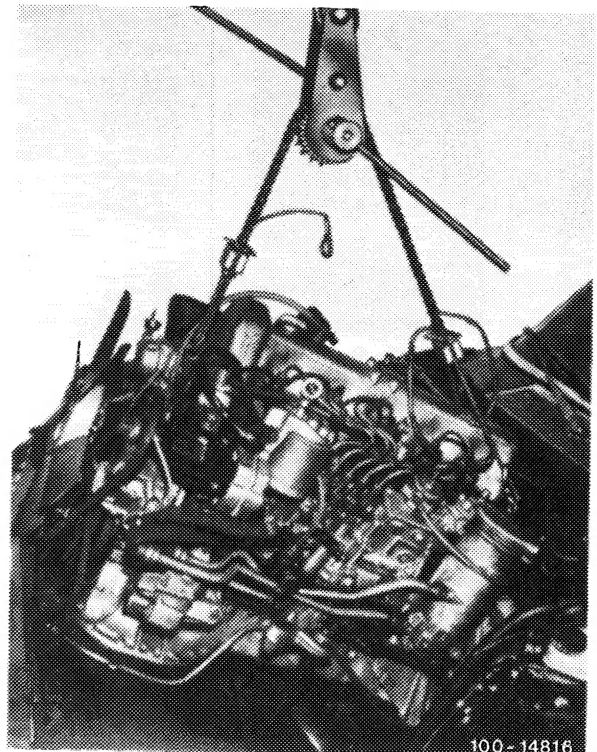
see illustration, job No. 4

#### Note

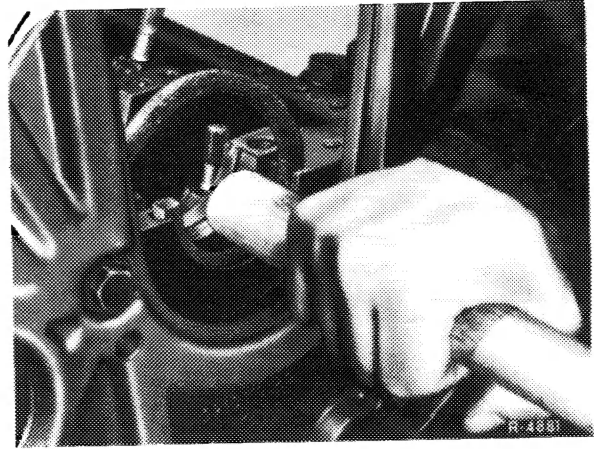
The radial seal is graphite gray in color.

#### Replacement

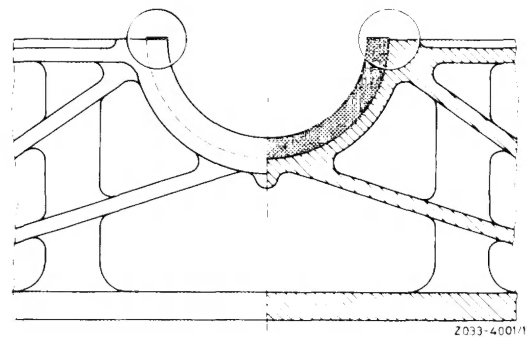
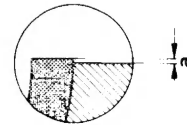
- 1 Remove engine (00–110).
- 2 Remove crankshaft.



3 Position radial seal in crankcase and oil pan, working into position with aid of oily hammer handle.

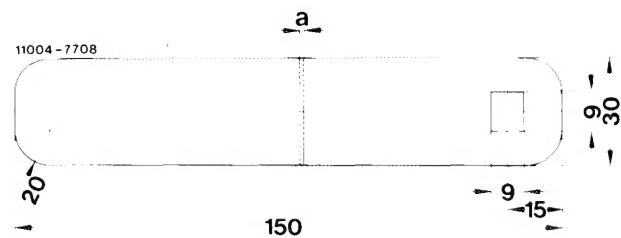


4 To obtain necessary overlap, cut off radial seal in crankcase and oil pan about 1.0 mm above parting surface.



Dimension a = 1.0 mm

**Note:** A shop-made gauge according to adjacent drawing can be used for cutting.



Dimension a = 1.0 mm

5 Apply oil to radial seal prior to installation of crankshaft.

6 Install crankshaft.

7 Attach oil pan, turn crankshaft and check for ease of movement.